

Date: Thursday, 22/11/2007 12:57:21 PM
User: Linda Lécelle

Process Sheet

827
ATO 8007/11/27

Customer : CC-DAR01 Dart Aerospace Ltd.
Job Number : 35962
Estimate Number : 10804
P.O. Number : N/A
This Issue : 22/11/2007 S.O. No. : N/A
Print Rev. : NC
First Issue : N/A Type : SMALL / MED FAB
Previous Run : 35961
Written By :
Checked & Approved By :
Comment :

Drawing Name : REWORK
Part Number : D2807041
Drawing Number : ECN 1019
Project Number : N/A
Drawing Revision : N/A
Material : N/A
Due Date : 29/11/2007

Qty: 50 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REMOVE FROM STOCK:

D2807 B3 3941

80 87/11/27

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
ADD D3671-1 PLACARD B 35613
TO D2807 (BECOMES D2807-041)
PER DRWG D2807-041

85 07/11/27

3.0 D2807 Gas Spring (Support Prop)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)
Gas Spring (Support Prop) B 33941

80 07/11/27

4.0 D36711 PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)
PLACARD B 35613

81 07/11/27

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

82 07/11/27

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: REWORK

Job Number: 35962

Part Number: D2807041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1

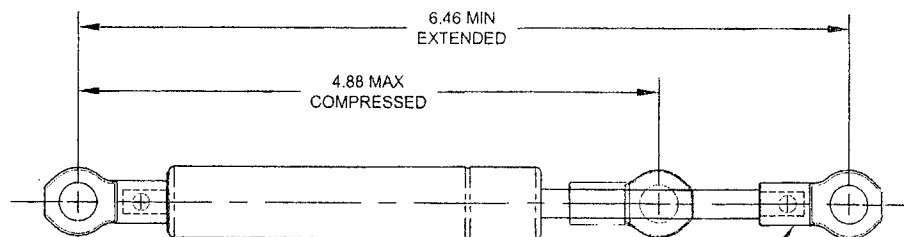


Comment: PACKAGING RESOURCE #1
RESTOCK USING NEW B/N

Job Completion

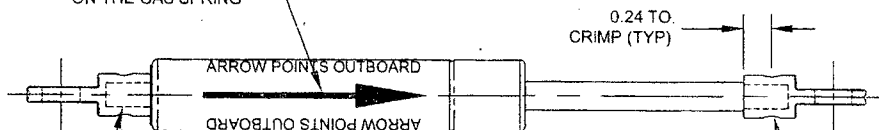


QC21 Final inspection w/o release ☒ 07/11/07
W Still 27



AFFIX D3671-1 PLACARD (1)
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING

D2807-3 LUG
(2 PLACES)



M5x0.8 THREADED ENDS,
ACCEPTABLE TO TRIM END
UP TO 0.050 TO MEET
COMPRESSED DIMENSION (TYP)

CRIMP 0.015-0.025" DEEP
WITH Ø0.375 TOOL AT
2000psi (REF), TYP TWO
SIDES PER LUG

D2807-1 GAS SPRING

NOTES:

- 1) MATERIAL: NONE - SEE NOTE #8
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.147 lbs
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS
POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE,
115N LOAD)

D2807-041 GAS SPRING ASSEMBLY

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.179 lbs

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-1	GAS SPRING
2	D2807-3	LUG
1	D3671-1	PLACARD

REV.	DESCRIPTION	BY	DATE
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.09.27		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2807 TITLE GAS SPRING SCALE 1:1 REV. D SHEET 1 OF 2 COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS CONTROLLED BY THE EXPORTS AND IMPORTS ACT (EIA) AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.			